



Dart Aerospace Ltd.
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Canada

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D119-796-251
Job Sheet 171242



Part No: D119-796-251

Job Qty: 1 ea

Part Name: Aft Crosstube Installation With Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/30/18

Job Tracking No:

Due Date: 2/19/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D119-796-251 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19 AS PER REV.C DD VERF:JLM IPP
REV:D 14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D JLM VERF:DD IPP
REV:F 17.12.11 REMOVE PACK KIT DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/17/18	0.00	0.00	Start Up Crosstubes-1		AS MAR 25 2018
130	Crosstubes	1 pcs		2/19/18	0.00	0.51	Crosstubes-1		AS MAR 25 2018
140	QC	1 pcs		2/19/18	0.00	0.00	QC5		30
145	DC	1 pcs		2/19/18	0.00	0.00	DC		N/R
150	Packaging	1 pcs		2/19/18	0.00	0.00	Packaging3-1	LGOSO	AS MAR 25 2018
160	QC21-FG	1 Ea		2/19/18	0.00	0.00	QC21		ms 18/03/26

Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-251 ***Torque all clamps to 50 IN-LBS max.***
Descriptions: 140 - ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***
145 - Photocopy bluefile and create labels as per PPP D119-796-251 chg 002
150 - Identify and pack for shipping as per PPP D119-796-251

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-796-241	Aft Crosstube Installation Without Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	
D5123-3	Clamp Cushion	4 Ea (4 ea)	90-Start up Operation	
D5149-043	Aft Step Base Assembly	2 Ea (2 ea)	90-Start up Operation	
MS21920-25	Clamp	4 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D119-796-241 169273	①	6	0
	D5123-3 5006028	④	338	0
	D5149-043 5022058	② 5049275	8	0
	MS21920-25 5024697	④	116	0



Container No: S054805



Part: D119-796-251

Job No: 171242

Serial No/Batch: S054805

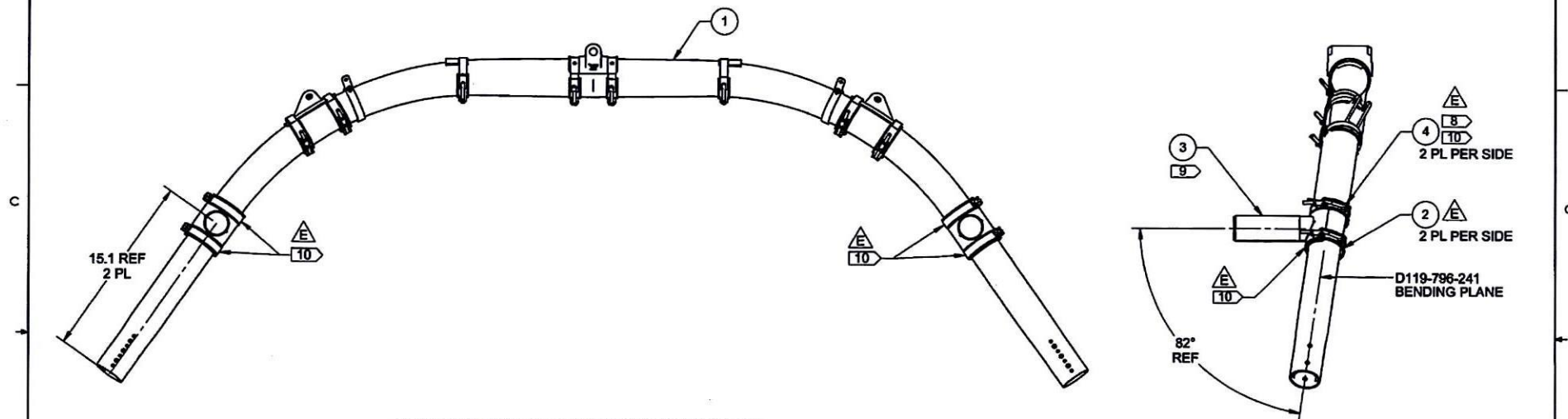
Revision: E/F

Inspector:

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8:14 AM Dart.Gagnon.Michelle

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
2	4	D5123-3	CUSHION
3	2	D5149-043	AFT STEP ASSY
4	4	MS21920-25	CLAMP



D119-796-251 XTUBE ASSY (AW119 MKII AFT)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171242

FEB 07 2018

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE
- 10) POSITION MS21920 CLAMPS SECURING THE STEPS AS SHOWN. THE THREADED PORTION OF THE CLAMP MUST FACE THE SAME DIRECTION AS THE STEP

REV.	DESCRIPTION	BY	DATE
E	MODIFY CLAMP ORIENTATION, ADD NOTE 10, REMOVED SECTION A-A (PAR16-527)	ML	17.02.10
D	D5123-3 WAS D5123-9, MS21920-25 WAS -26, ADDED SECTION A-A	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A	AP	14.10.04
A	NEW ISSUE	AP	14.09.03
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D119-796-251 TITLE XTUBE ASSY (AW119 MKII AFT) COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	ML		
CHECKED	NO		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS	REV. E SHEET 1 OF 1 SCALE NTS	
DATE	17.02.10		

RELEASED
2017-05-04
ECN17-538

APPROVED

Change Record

PAGE 1 OF 1

Part Number: D119-796-251

Description: CROSSTUBE INSTALLATION, AFT STD, WITH PEG STEPS

[illegible]